

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018538**Date Inspected:** 09-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Wang li yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

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The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07702.

Ultrasonic Testing (UT)

This QA performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated UT report for this date. The members are identified as OBG Vertical, side and longitudinal diaphragm plate weld Components. Total number of welds UT Tested: 13 No's. The weld designations are review as follows:

1. VP3018-001-004,005,006
2. LD3051-001-039,041,032,030,023,025,014,016
3. SP3145-001-007
4. SP3131-001-013

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This QA Inspector Randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) welding of weld joint FB3343-001-039,043. Welder is identified as 067876. ZPMC Quality Control (QC) is identified as Mr. Tian lei. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2233-ESAB.

FCAW welding of weld joint FB3343-001-040,044. Welder is identified as 067876. ZPMC Quality Control (QC) is identified as Mr. Tian lei. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2232-ESAB.

FCAW welding of weld joint FB3343-001-053,057. Welder is identified as 058245. ZPMC Quality Control (QC) is identified as Mr. Tian lei. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2233-ESAB.

FCAW welding of weld joint FB3343-001-082,086. Welder is identified as 045209. ZPMC Quality Control (QC) is identified as Mr. Tian lei. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2232-ESAB.

ZPMC MT Technicians performing MT for the welds located on LD3049B. Refer the attached photos for reference.

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Shielded Metal Arc welding (SMAW) Tack welding of weld joint SA8009-001-001. Welder is identified as 058102. ZPMC Quality Control (QC) is identified as Mr. Wang li yang. The welding variables appeared to comply with the Applicable WPS: WPS-B-P-2231-TC-U4b.

SMAW Tack welding of weld joint AH3150A-008,009. Welder is identified as 051359. ZPMC Quality Control (QC) is identified as Mr. Wang li yang. The welding variables appeared to comply with the Applicable WPS: WPS-B-P-2112.

This QA Inspector performed photo documentation on Lift 14 Hinge plates are identified as FB3343A, located in sub assembly bay 2. These photos have been sent to QA lead Inspector and Structural Material Representative (SMR) by mail.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Prabhu,Surendra

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer